



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3196-1**Job Sheet 191868****Part No:** D3196-1**Job Qty:** 6 pcs**Part Name:** Bar**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/11/19**Job Tracking No:****Due Date:** 4/10/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C IPP Rev: A New Issue 05-11-08 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier				
100	Bandsaw - 1	6 pcs		4/10/19	0.00	0.25	Bandsaw - 1			52	
110	HAAS 4 Axis - B4B	6 pcs		4/10/19	0.47	5.45	HAAS - 1 - B4B			52	19/05/26
							HAAS - 2 - B4B			9-89	
							HAAS - 3 - B4B				
							HAAS - 4 - B4B				
120	QC 2	6 pcs		4/10/19	0.00	0.00	QC 2 - 1				
							QC 2 - 12				
							QC 2 - 14				
							QC 2 - 17				
							QC 2 - 19				
							QC 2 - 2				
							QC 2 - 20				
							QC 2 - 22				
							QC 2 - 23				
							QC 2 - 25				
							QC 2 - 32				
							QC 2 - 33				
							QC 2 - 35				
							QC 2 - 39				
							QC 2 - 4				
							QC 2 - 40				
							QC 2 - 44				
							QC 2 - 45				
							QC 2 - 48				
							QC 2 - 49				
							QC 2 - 50				
							QC 2 - 51				
							QC 2 - 52			52	19/05/26
							QC 2 - 54			9-89	
							QC 2 - 56				

container # 5184059



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184059**Part:** D3196-1**Job No:** 191868**Serial No/Batch:** 3134059**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 05/28/19

Plex 3/11/19 11:00 AM Dart.lajeunesse.marie

					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 8 - 12	
130 QC 8	6 pcs	4/10/19	0.00	0.00	QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140 Handfinish - 1-1 Chemical- B4B	6 pcs	4/10/19	0.00	0.45	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 -	

★ MAY 27 2019

				B4B	
				Handfinish - 1 - 22 - B4B	
145	Outsource	6 pcs	4/10/19	0.00 0.00	
150	Powdercoat - 3 Grey Sand - B4B	6 pcs	4/10/19	0.00 0.30	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
155	Packaging 3-1 - Stock - B4B	6 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
160	QC 3	6 pcs	4/10/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
170	Packaging 3-1 - Stock - B4B	6 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B

DAS
35
9-89

BL 09-05-28

START: 9:10 OUT: 9:30 FINISH: 9:40

DAS

MAY 28 2019 40

9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	2
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
180 QC 21 - SA	6 pcs	4/10/19	0.00 0.00	QC 21 - SA - 21	MAY 20 2019 DAS
				QC 21 - SA - 70	70
				QC 21 - SA - 53	9-89
Part Op 100 - (Bandsaw) Cut blank: (0.75" x 1.50") x 26.200" long Bar Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	13.0980 ft (2.183 ea)	100-Bandsaw - 1	S16 8972	
				5184057	
				5184058	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B0.750X01.500	13	41	0	

MAT
used
13.125'

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bar	26.094inches ± 0.010	26.104 26.084	26.094	
2	Bar	4.045inches ± 0.010	4.055 4.035	4.045	
3	Bar	18.003inches ± 0.005	18.008 17.998	18.002	
4	Bar	0.750inches ± 0.005	0.755 0.745	0.750	
5	Bar	1.500inches ± 0.010	1.510 1.490	1.503	
6	Bar	0.344inches $+ 0.006$ $- 0.001$	0.350 0.343	0.345	Diameter
7	Bar	0.660inches $+ 0.008$ $- 0.001$	0.668 0.659	0.663	Diameter
8	Bar	100.000Degrees ± 0.500	100.500 99.500	100°	
9	Bar	0.060inches ± 0.010	0.070 0.050	0.06	
10	Bar	45.000Degrees ± 0.500	45.500 44.500	45°	
11	Bar	0.750inches ± 0.010	0.760 0.740	0.751	
12	Bar	0.250inches ± 0.010	0.260 0.240	0.251	
13	Bar	3.495inches ± 0.010	3.505 3.485	3.495	
14	Bar	9.000inches ± 0.010	9.010 8.990	8.998	
15	Bar	16.844inches ± 0.010	16.854 16.834	16.840	
16	Bar	21.498inches ± 0.010	21.508 21.488	21.502	
17	Bar	0.125inches ± 0.010	0.135 0.115	0.125	Radius
18	Bar	1.100inches ± 0.010	1.110 1.090	1.097	
19	Bar	0.125inches ± 0.010	0.135 0.115	0.125	Radius
20	Bar	0.444inches ± 0.010	0.454 0.434	0.442	

Plex 3/11/19 11:00 AM Dart.lajeunesse.marie

DAS
52
9-89 19/05/20